

Work Order ID 58402

May 5, 2010 3:08:03 PM



Page 1

Item ID: D3393-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Battery Lock Assembly

Start Date: 5/05/10 Start Qty: 5.00



Cust Item ID:

Required Date: 5/06/10 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3393

Rev A

100

0.00

⑤



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest. 12-Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-5 13-Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten

SB 10/05/04

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Tack Weld lock shaft to flat cam of a Max 1/8" Long 1 QtyPart Number Description Batch: A/RN/A SS Rod M108160

12 10-5-6

⑤

120

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

⑤

PD 10.05.07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Set Up/
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Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Apply Crazy Glue to cap and press into Body 119567K21
Batch M114534

8 10/05/07

5

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8 10/05/07

45

150



Packaging

Packaging

Identify as per dwg & Stock Location: 486

Memo

0.00

0.00

10-5-7 5/5

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Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/07
MF
10-5-7

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 58402

Parent Item: D3393-041

Parent Item Name: Battery Lock Assembly











Start Date: 5/05/10

Required Date: 5/06/10

Comments: IPP Rev:A New Issue 05-11-22 JLM

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
5/16WC  SS Flat Washer 5/16		Purchased	No			100	Each	374.0000	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST377		374						
				112560		374						
9567K21  Polyethelene Cap		Purchased	No			100	Each	99.0000	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST380		99						
				110822		99						
D2728-7  Dart Logo label		Manufactured	No			100	Each	0.0000	0			
D3373-1  Cam Lock		Manufactured	No			100	Each	14.0000	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST052		14						
				44105		14						
D3393-1  Battery Lock Casing		Manufactured	No			100	Each	5.0000	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST486		5						
				50476		5						

10 SS 10/05/07 (5)

10 SS 10/05/07 (5)

SS 14/05/07 (5)

5 SS 10/05/07 (5)

5 SS 10/05/07 (5)

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 2

Work Order ID: 58402

Parent Item: D3393-041

Parent Item Name: Battery Lock Assembly

Start Date: 5/05/10

Required Date: 5/06/10

Comments: IPP Rev:A New Issue 05-11-22 JLM

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3393-3		Manufactured	No			140	Each	22.0000	1			



Cam Lock Shaft



Location

Loc Qty

Loc Code

ST055

22

44108

2

48630

20

2
3

8 14/05/07 5

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

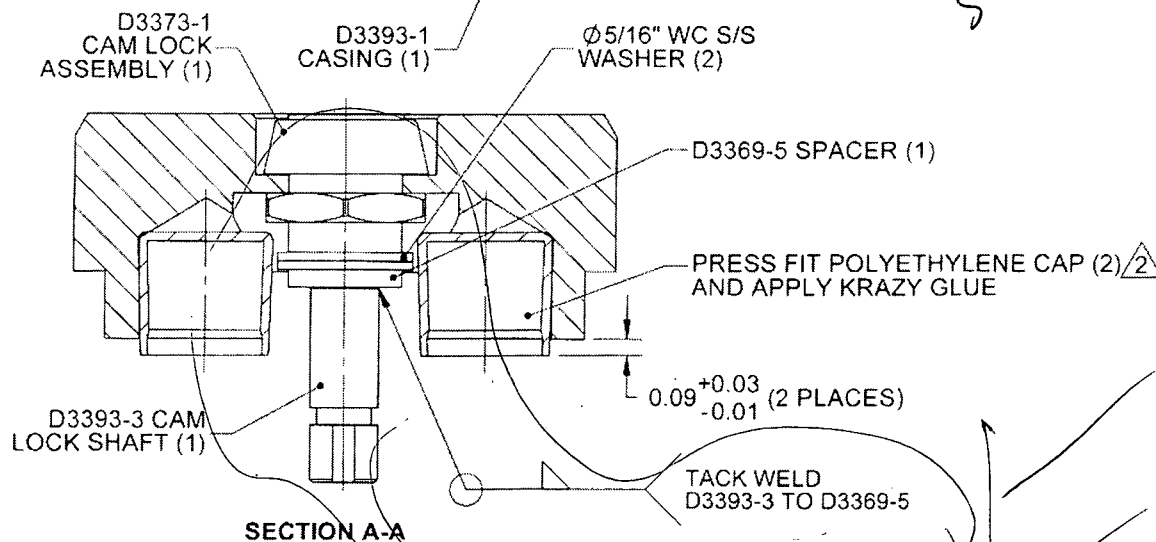
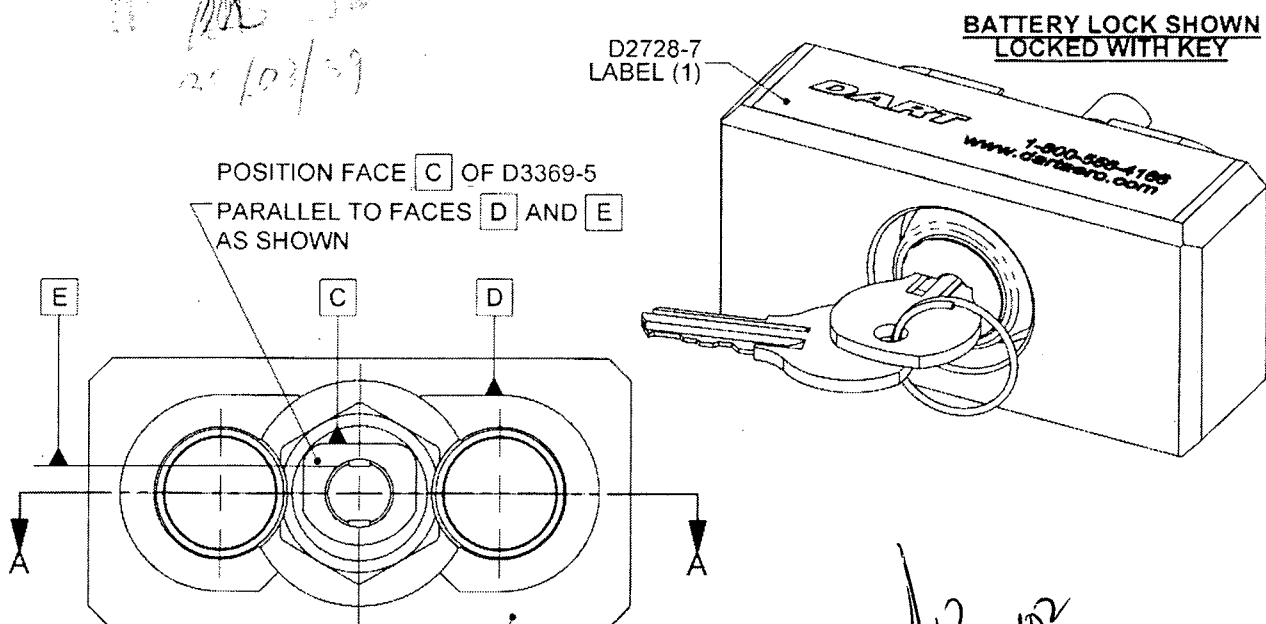
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NOTE: Date & initial all entries



DESIGN 43	DRAWN BY 43	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 72	APPROVED 43	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	



D3393-041 BATTERY LOCK ASSEMBLY

NOTES:

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

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Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

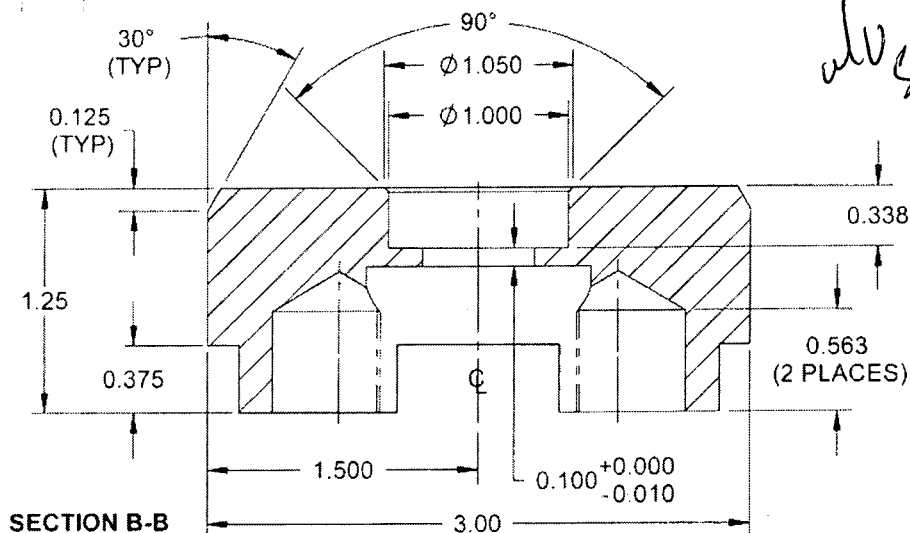
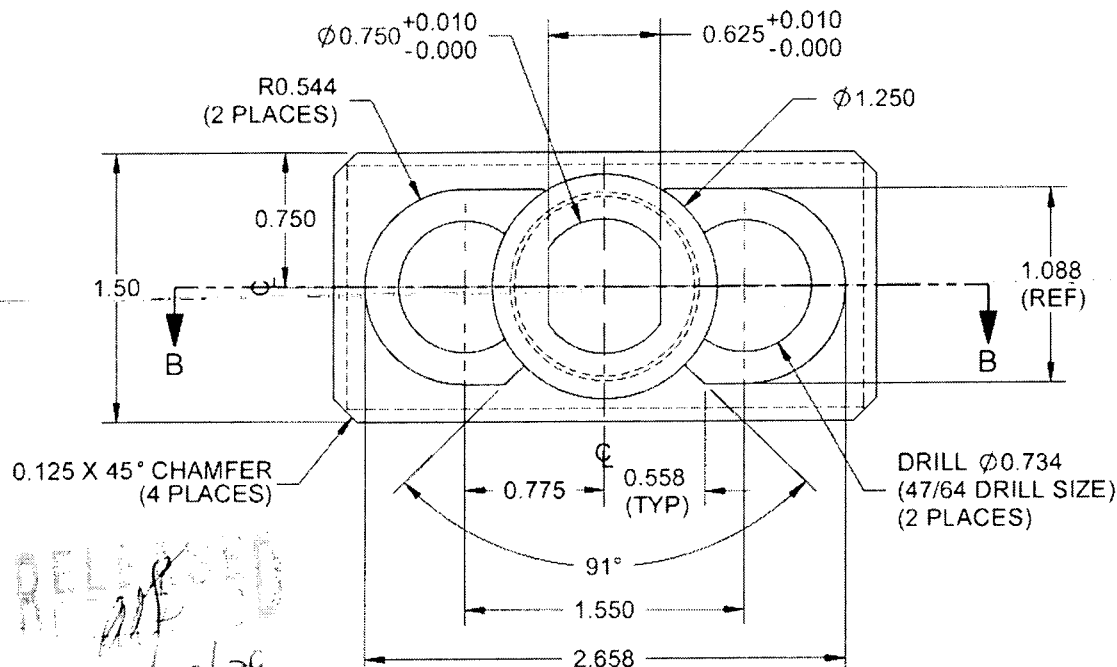
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 17	APPROVED 17	DRAWING NO. D3393	REV. A SHEET 2 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 1:1



D3393-1 CASING

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

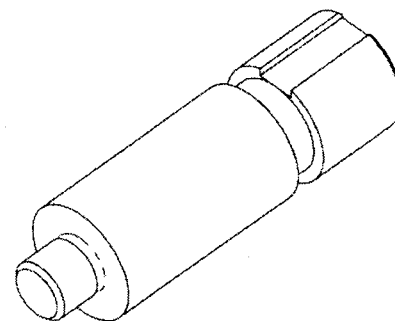
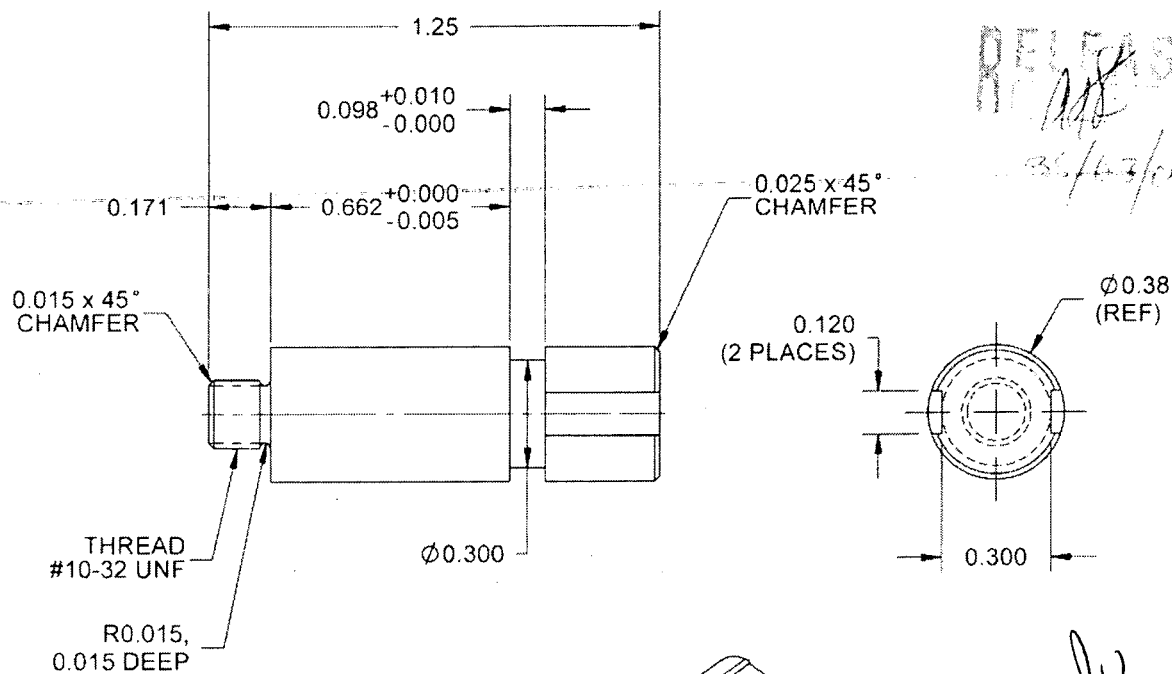
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05.02.09	TITLE BATTERY LOCK		SCALE 2:1



D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

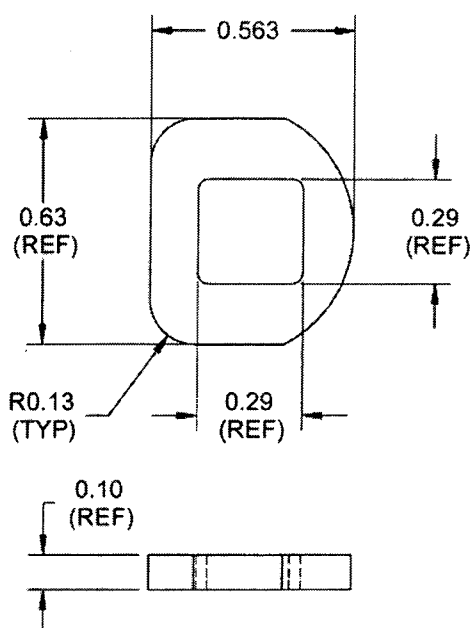
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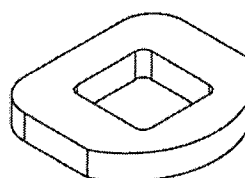
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3369	REV. A SHEET 4 OF 4
DATE 04.12.16	TITLE BATTERY LOCK	SCALE 2:1	

SPECIFICATION CONTROL DRAWING



RELEASED
[Signature]

05/02/11



-5
D3369 SPACER



NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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